

Date: Thursday, 3/23/2006 3:14:37 PM
User: COSS systems

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 26359		
Estimate Number	: 12116		
P.O. Number	: N/A	Part Number	: D335313
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D3353 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/23/2006 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/30/2006
Checked & Approved By	: <u>SW</u>	Qty:	8 Um: Each
Comment	: est rev A 06.01.26 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018TR1250W109	1010-1025 Steel Tubing
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Comment: Qty.: 0.9188 f(s)/Unit Total : 7.3500 f(s)

AISI 1018-1025 mild steel seamless round tubing

1.250" od X 0.109" wall

batch: M15925 M1018IR 16949

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 10.50" long as per dwg D3353

AD

06.03.23

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Drill & tap as per dwg D3353

AD

06.03.24

8

2-Deburr as per dwg D3353

AD

06.03.24

8

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

EP 06/03/24

8

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST428

C 206/03/27

8

Date: Thursday, 3/23/2006 3:14:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 26359

Part Number: D335313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/03/08 (8)

Job Completion



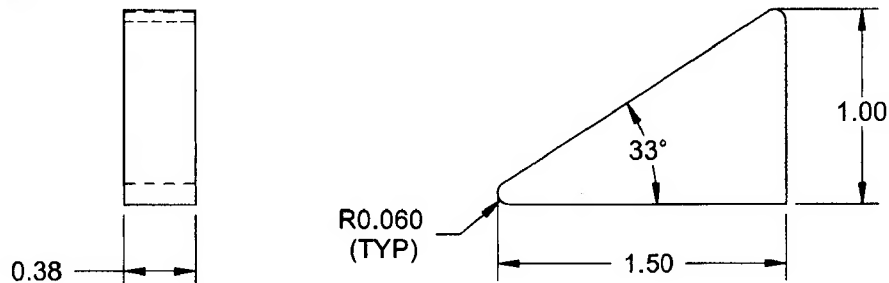
u 06.03-28

DART

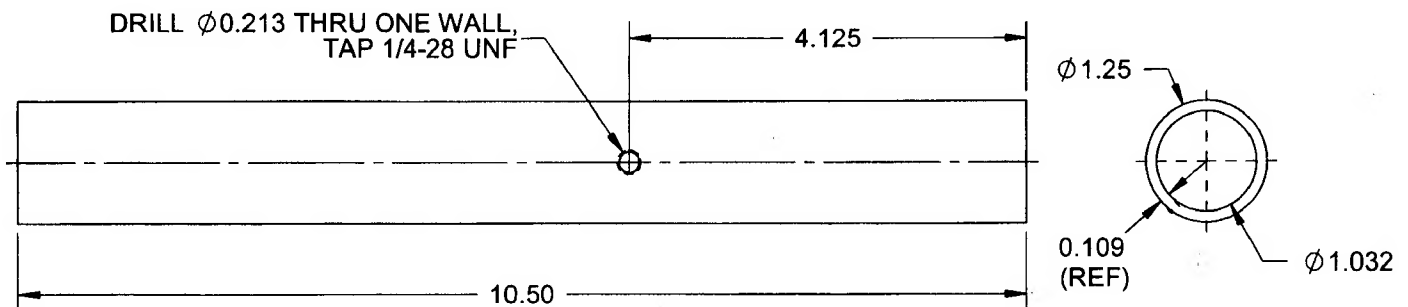
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 7 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
3-13-09

[Signature]

**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26359
Description: Lug weldment		Part Number:	D3353-13
Inspection Dwg:	D3353	Rev:	A
			Page 1 of 1


Part Number: D3353-13

Inspection Dwg: D3353 Rev: 1A

Page 1 of 1

☒ First Article ☐ Prototype

[illegible]

Measured by: 
Date: 06/03/24

Audited by:	En
Date:	06/03/24

Prototype Approval: **N/A**
Date: **N/A**

Rev	Date	Change
1		New Issue

Revised by _____ Approved _____
KJ:RE